




APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03985			SHEET 1 OF 2	
	DWG NO. 647.0100	REV: A	PREPARED BY J. BECKER	DATE: 7/15/13	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
	DWG TITLE: SHEET METAL				
	APPROVED BY: ENGR. 	MFG 	QC 	EFF. NEXT ORDER	
TRANSACTION CODES (TC): A-ADD R-REVISE C-CREATE D-DELETE	REASON: REVISED NOTE 2. ADDED 647.0117				

IS

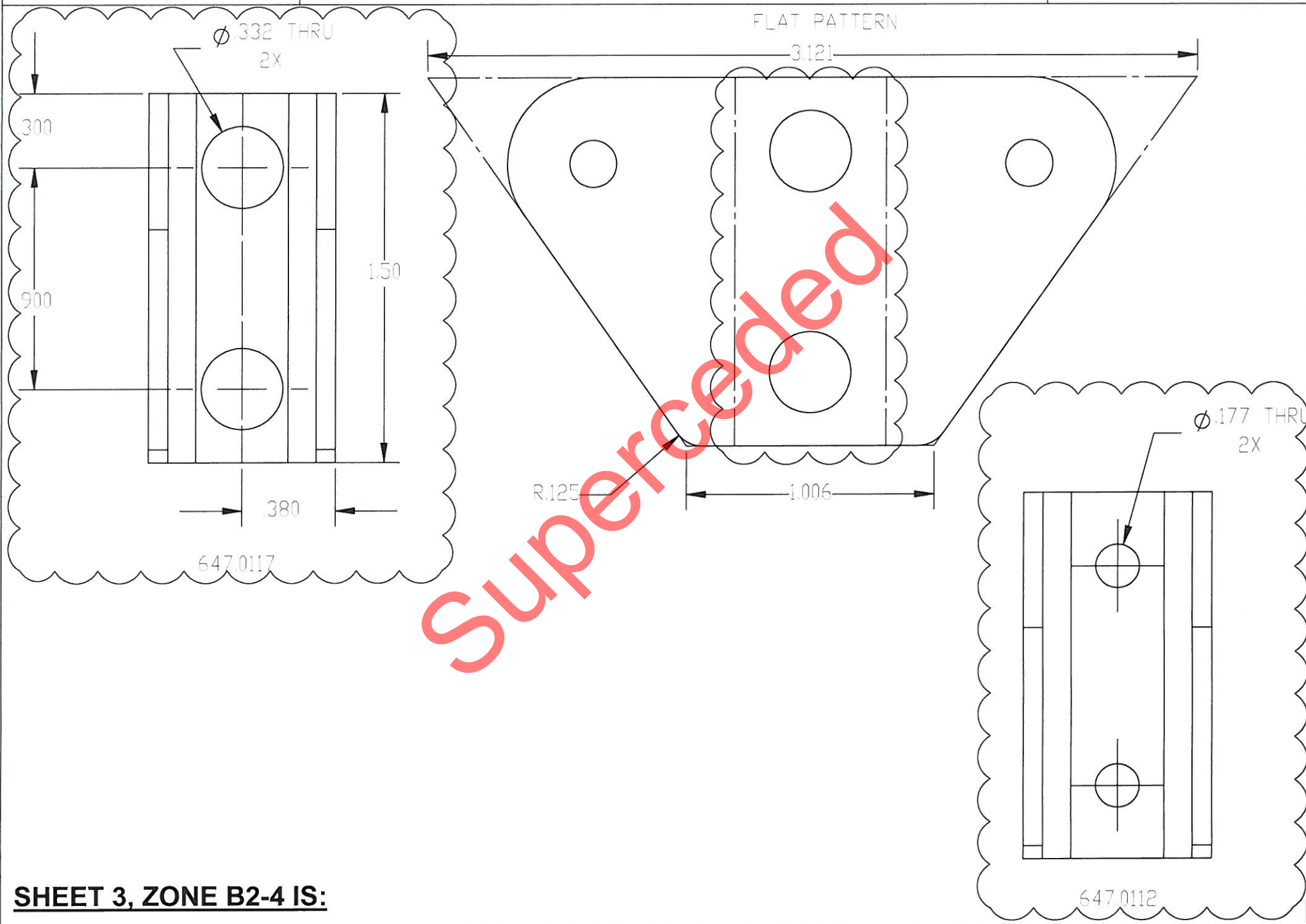
NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1, PRETREATMENT IAW SECTION 3.1 AND PRIMER IAW SECTION 4.1.
- 3. DEBURR AND BREAK ALL SHARP EDGES.
- 4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.
- 7 OTHER DIMENSIONS SAME AS 647.0112.

Superseded

SHEET 1, ZONE D1 IS:

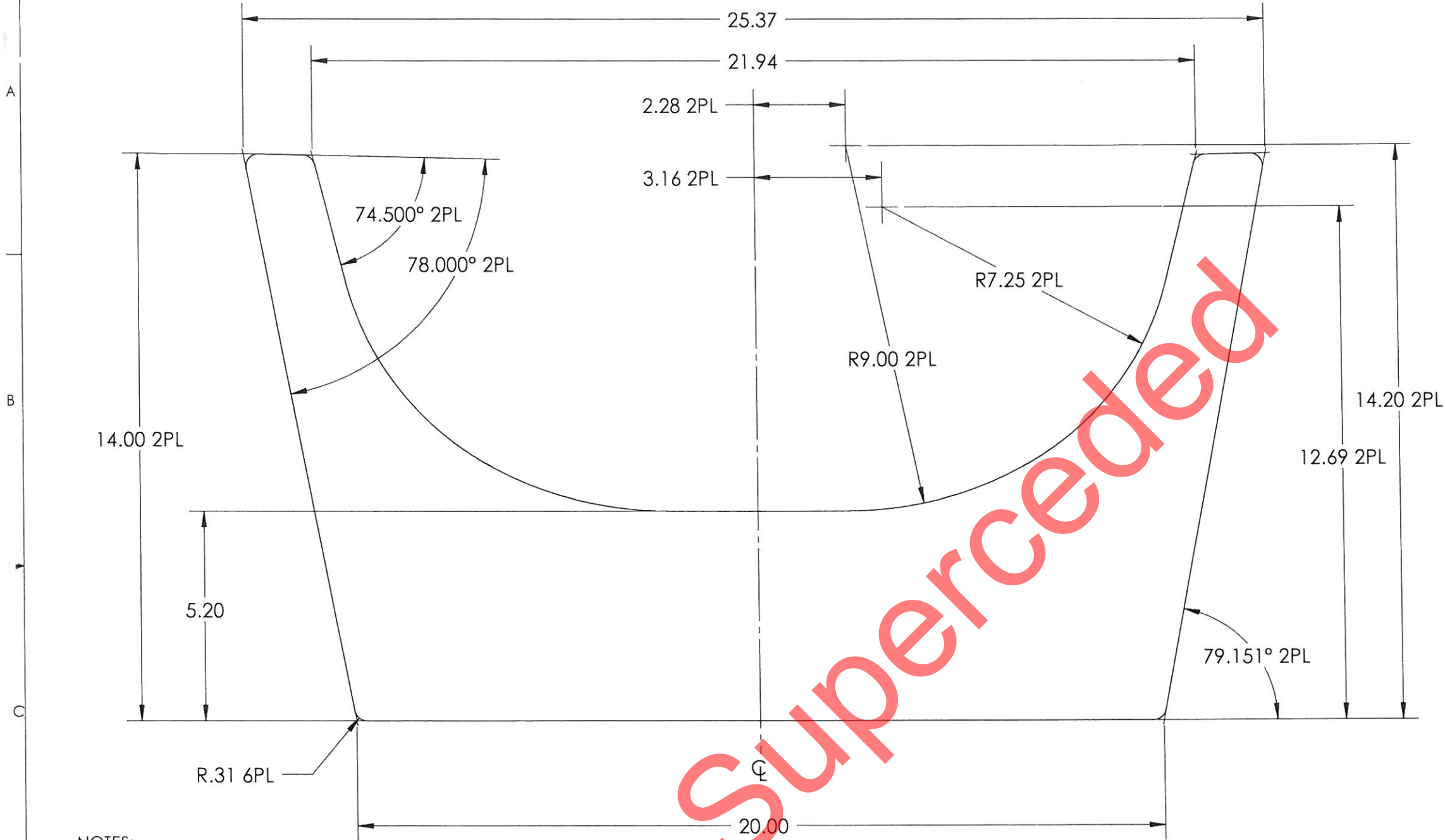
	C	647.0117		STRUT BRACKET	△	△
F/N	TC	PART NUMBER		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED: <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUCTIONS <input type="checkbox"/> ICA <input type="checkbox"/> FMS <input type="checkbox"/> BOM					CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO



SHEET 3, ZONE B2-4 IS:

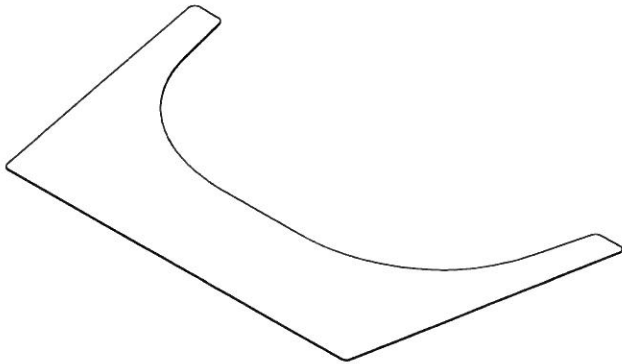
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR2		N/C
N/C	INITIAL RELEASE	05/28/09	P. BRAVO
A	INCORPORATED ECN 02722, 02964, 03089	04/28/11	P. BRAVO



NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.

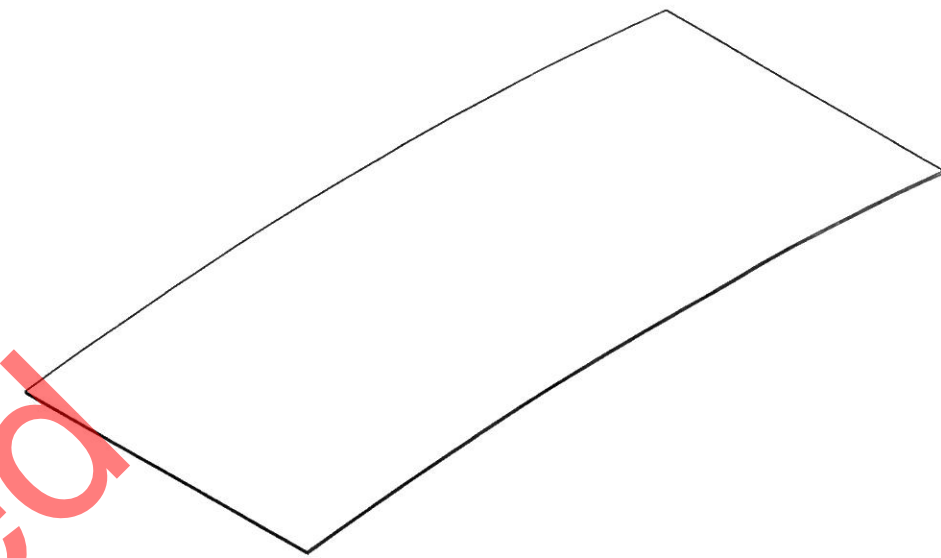
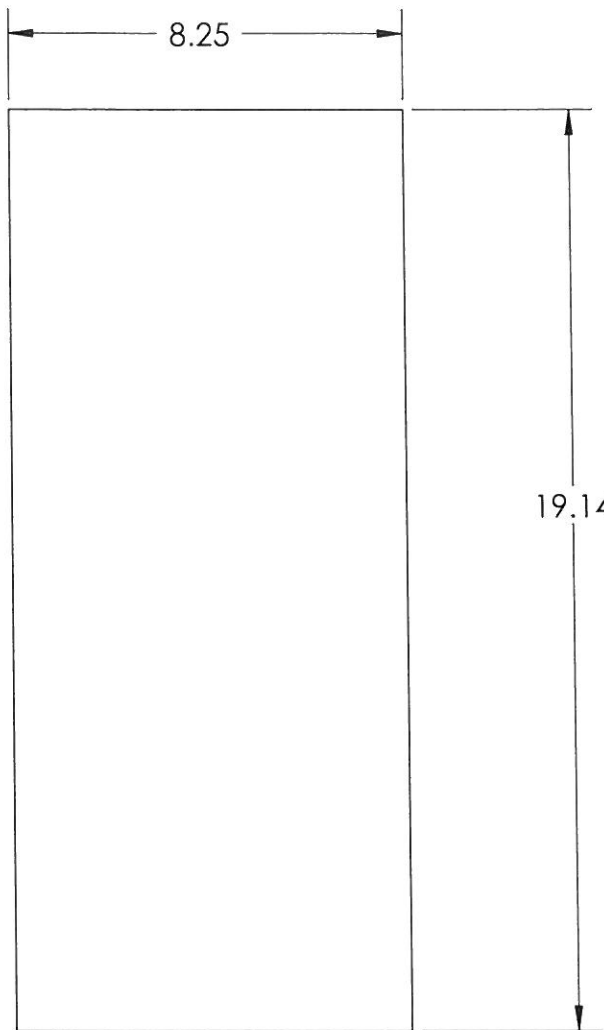


647.0110

			647.0116	DOUBLER	△1	△2
			647.0115	CLIP	△1	△2
			647.0114	CLIP	△1	△2
			647.0113	STRUT DOUBLER	△1	△2
			647.0112	STRUT BRACKET	△5	△6
			647.0111	PANEL	△1	△2
			647.0110	ROOF DOUBLER	△1	△2
		FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
		QTY		PARTS LIST		
		NEXT ASSY (S)		ORIGINAL DATE (MO-DA-YR) 05-28-09		
		646.9500		DRAWN BY R. ROSANO	CHECKER P. BRAVO	
				DRAWING APPROVAL P. BRAVO 05-28-09		
				CONTRACT No.		
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		
				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
				SHEETMETAL		
				SIZE B	CAGE CODE 07MZ6	DWG. 647.0100
				SCALE NONE		REV A
						SHEET 1 OF 6

1 2 3 4 5 6 7 8

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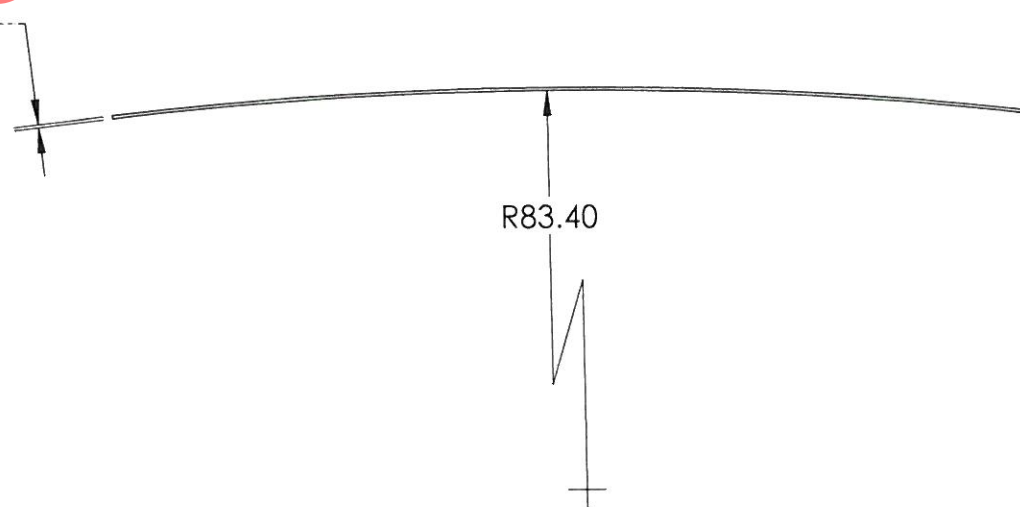


647.0111

FLAT PATTERN



.063

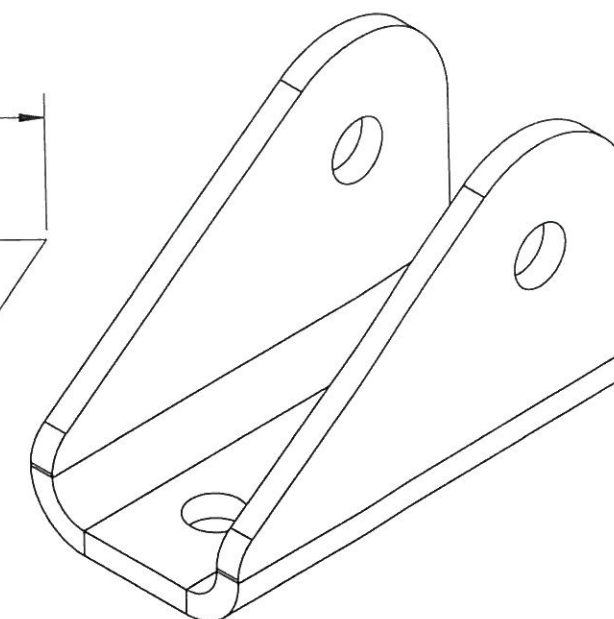
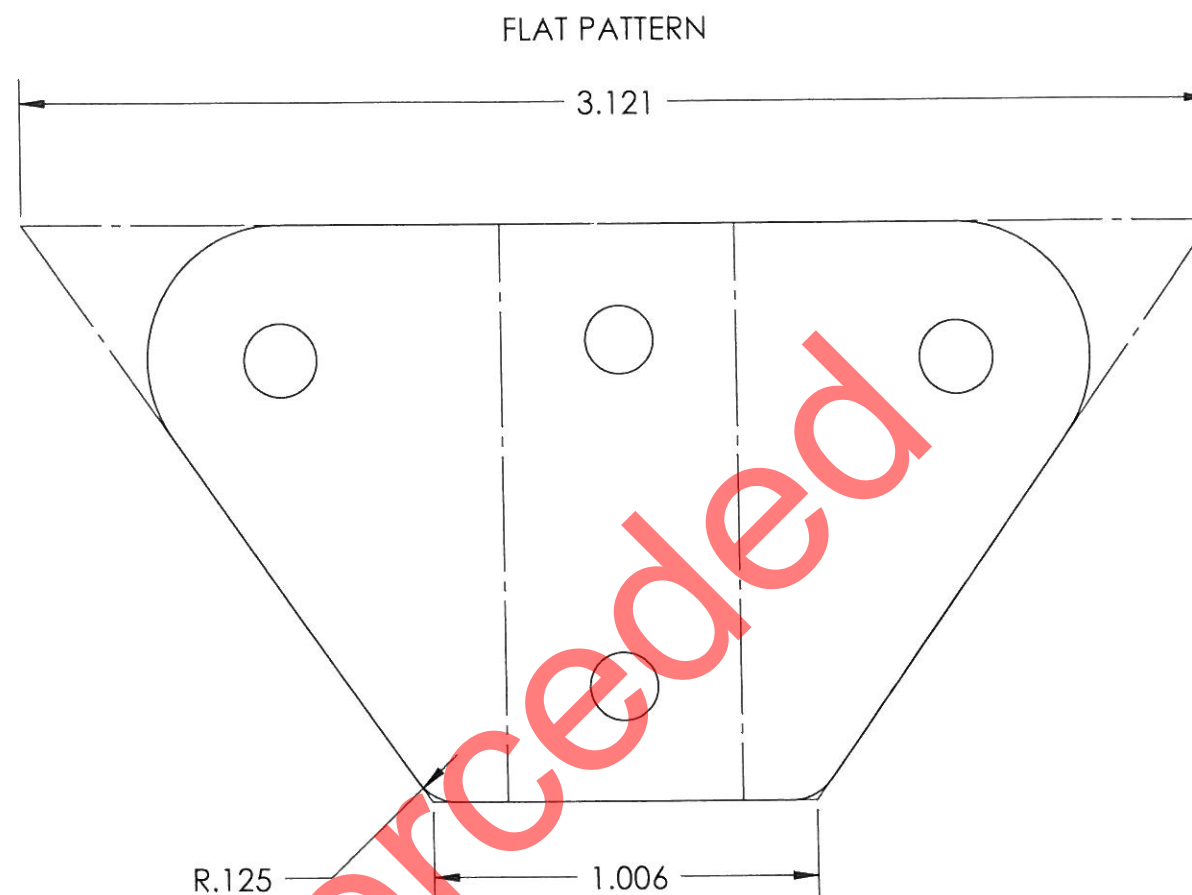
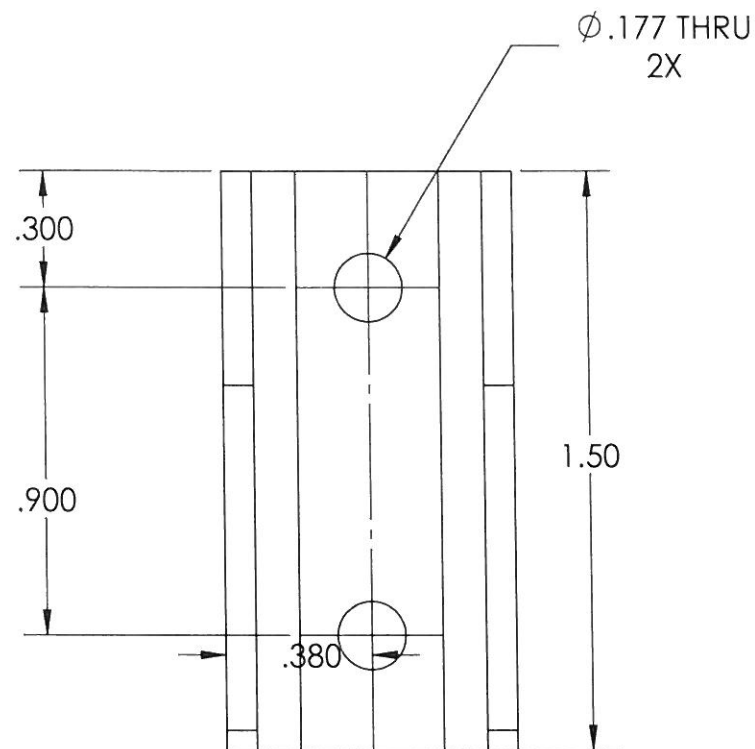


R83.40

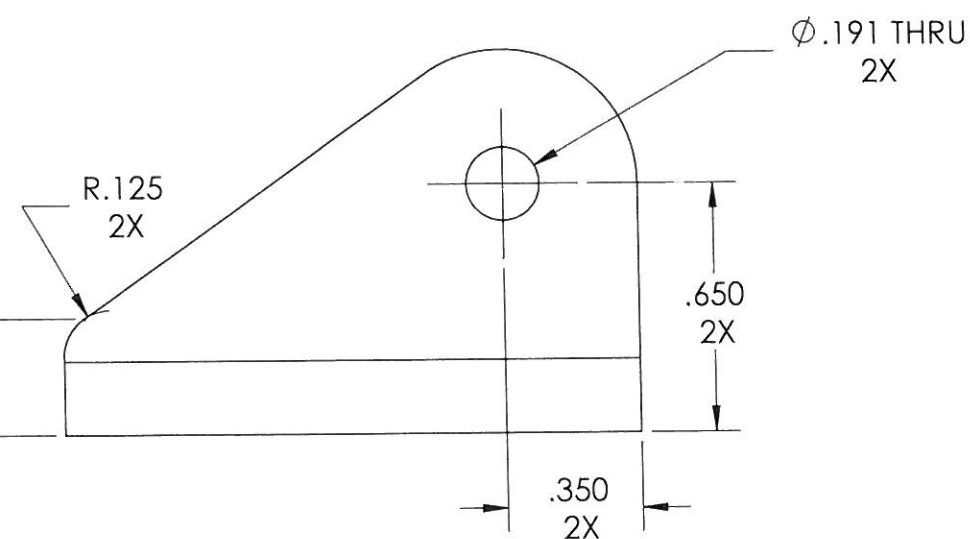
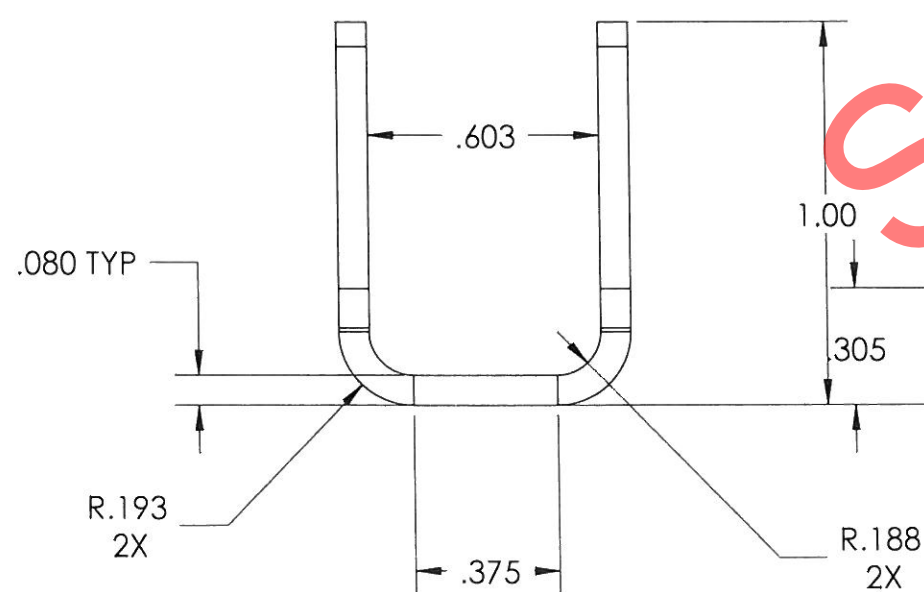
ORIGINAL DATE (MO-DA-YR) 05-28-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO		SHEETMETAL	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± 5°		SIZE B	CAGE CODE 07MZ6
		DWG. NO. 647.0100	REV. A
		SCALE: NONE	
		SHEET 2 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



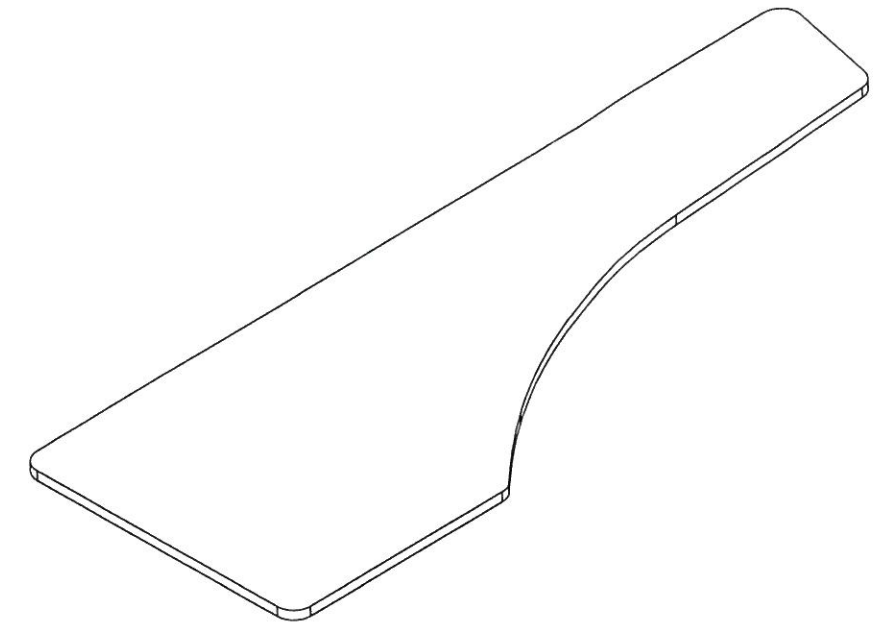
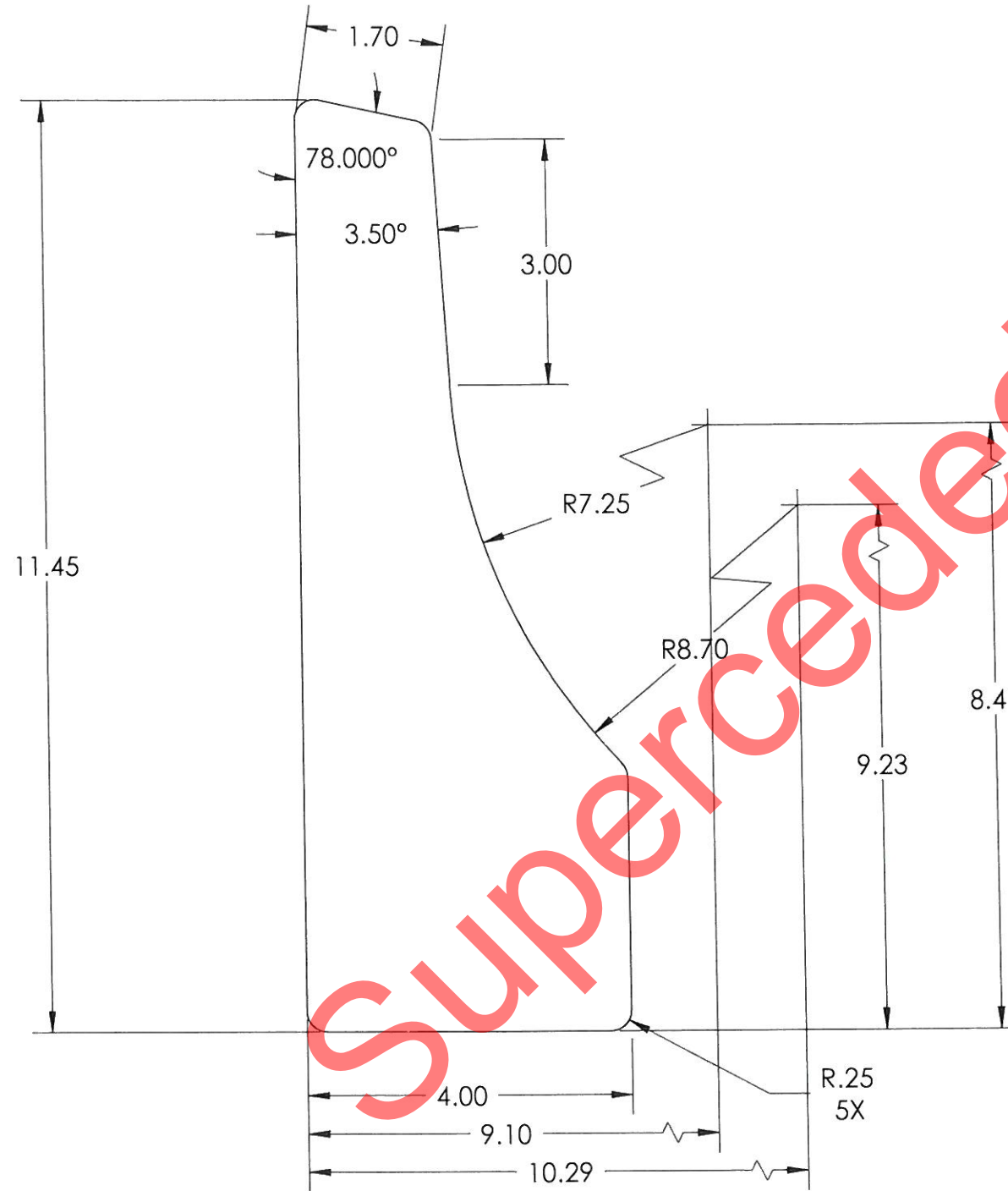
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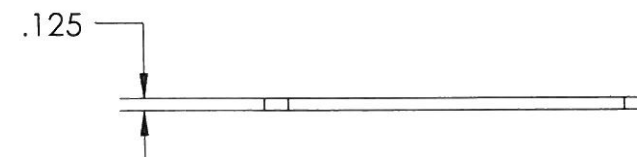
ORIGINAL DATE (MO-DA-YR) 05-28-09		APICAL INDUSTRIES	
DRAWN BY R. ROSANO	CHECKER P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAVO 05-28-09		SHEETMETAL	
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		SHEET 3 OF 6	

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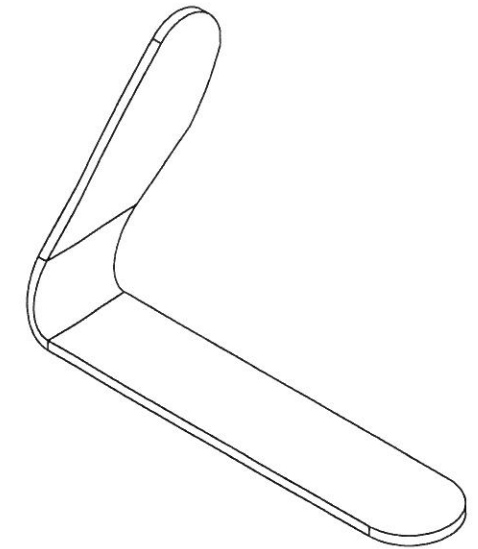
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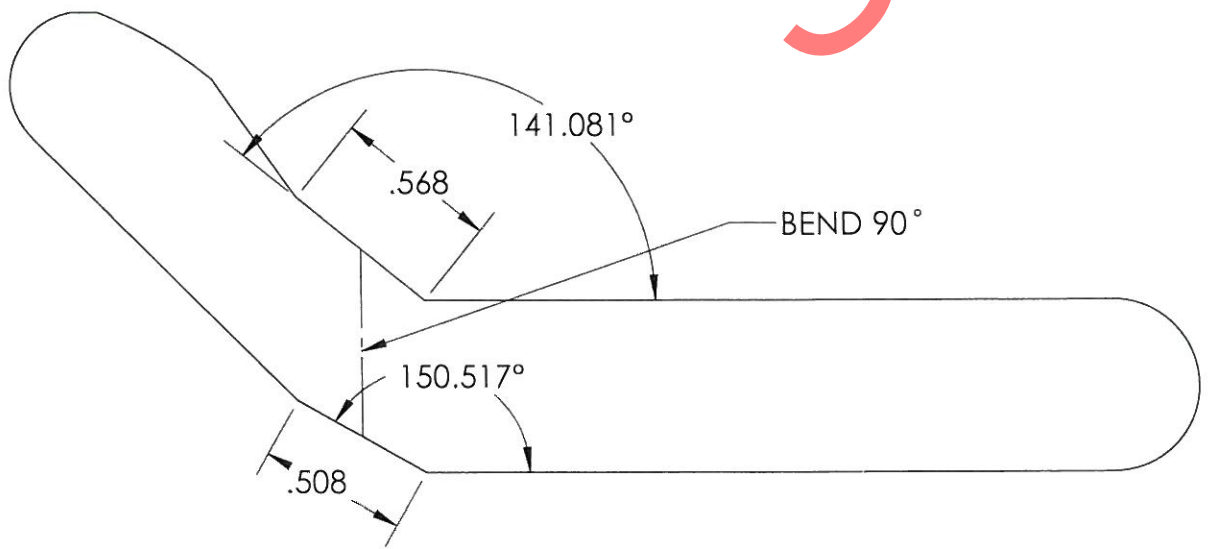
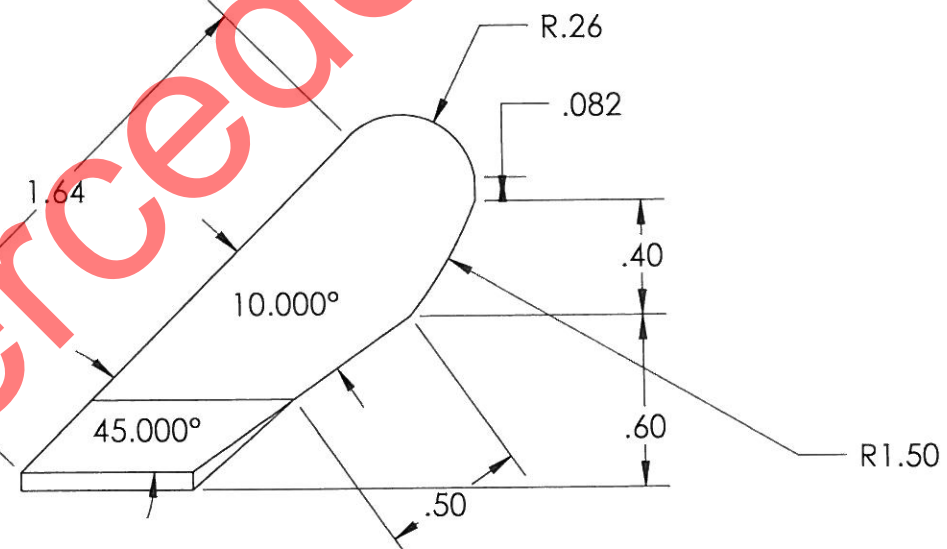
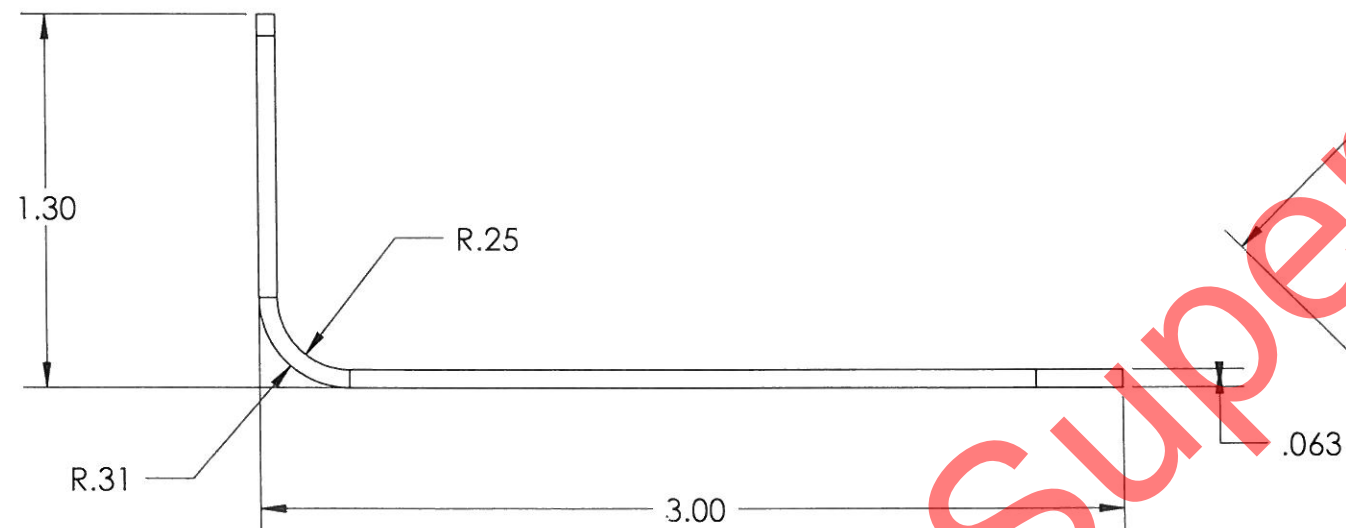
ORIGINAL DATE (MO-DA-YR) 05-28-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY P. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 05-28-09		SHEETMETAL	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± 5°		SIZE B	REV. A
CAGE CODE 07MZ6		DWG. NO. 647.010J	
SCALE NONE		SHEET 4 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0114 SHOWN
647.0115 OPPOSITE

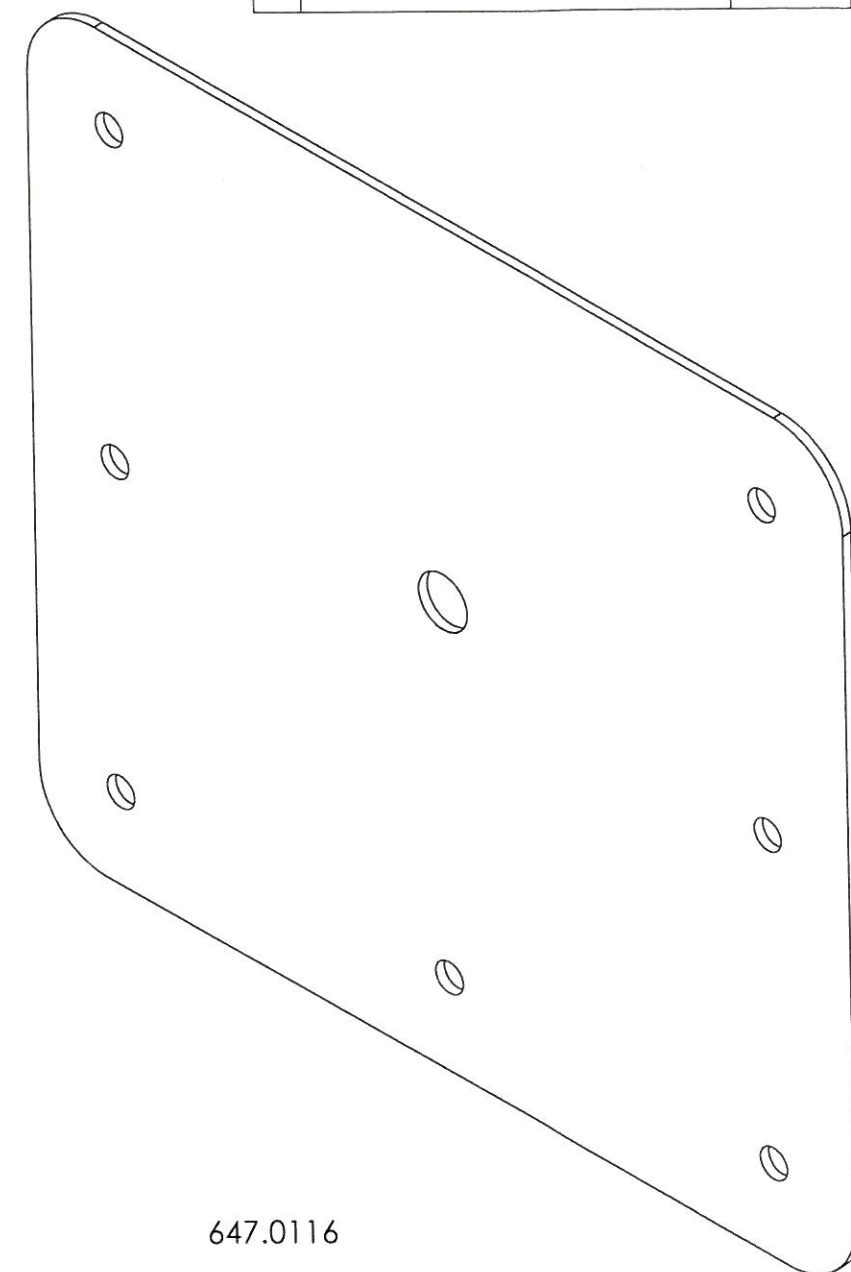
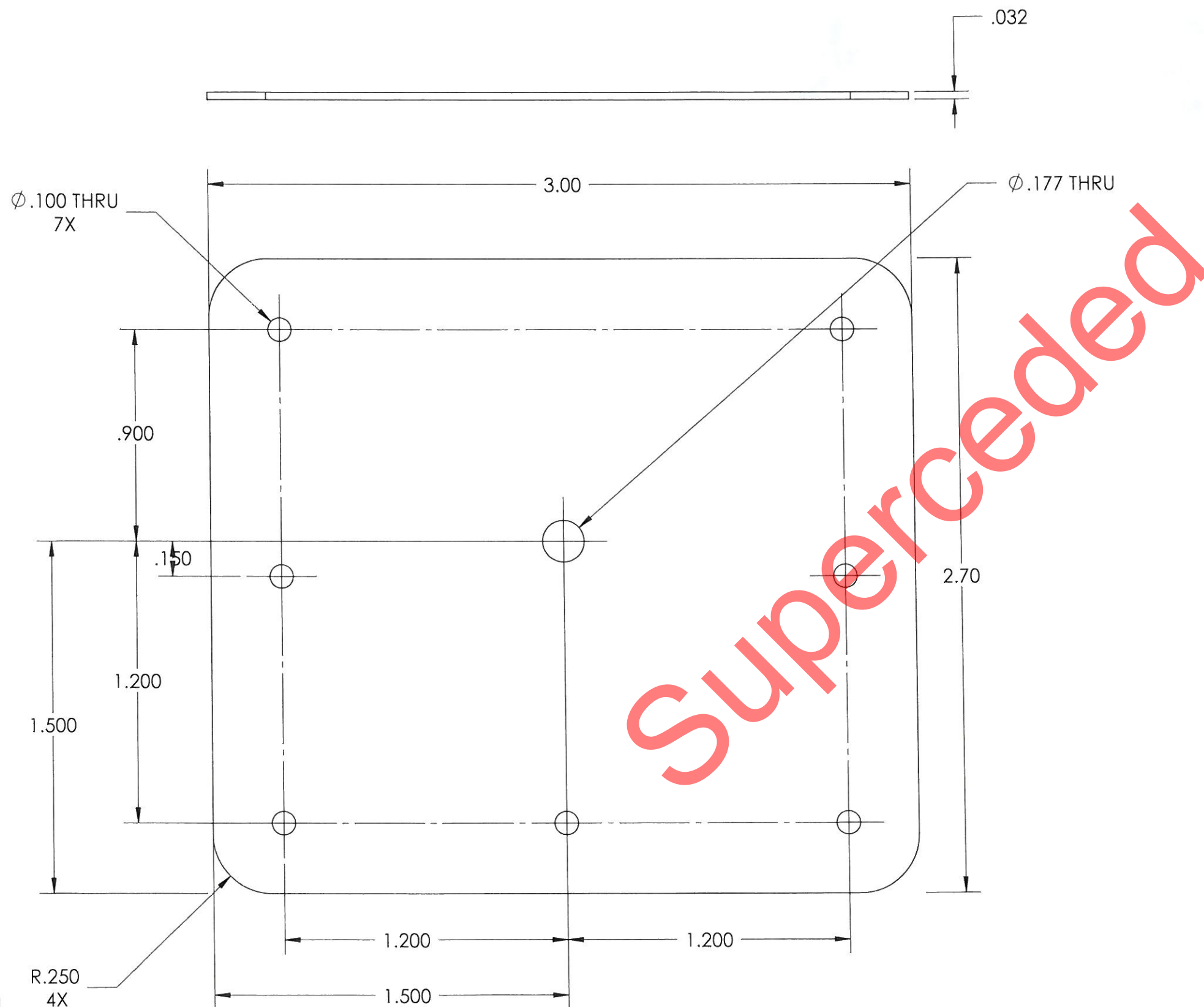


FLAT PATTERN

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DRAWING APPROVAL P. BRAVO 05-28-09		SHEETMETAL	
CONTRACT NO.		SIZE B	REV. A
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		SCALE NONE	SHEET 5 OF 6

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SCALE NONE	REV. A	SHEET 6 OF 6	